

Date: Tuesday, 31/03/2009 1:04:47 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE ASSEMBLY
Job Number : 46746	
Estimate Number : 10439	
P.O. Number :	Part Number : D3331041 FR
This Issue : 31/03/2009 S.O. No. :	Drawing Number : D3331 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 45279	Material :
Written By :	Due Date : 07/04/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.03.31</u>	
Comment : Est: C 05.05.26 Added D3158-050 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M1025TR0.875W125	1025 Round tubing .875 x .125w
Comment: Qty.: 1.5000 f(s)/Unit Total : 6.0000 f(s) 1025 Round Steel Bar Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall (M1025TR0.875W.125) Batch: <u>M10250 SAN 09-05-06</u> (4)		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1- Cut handle to finish length as per Dwg D3331 2- Form as per Dwg D3331 using DT8760 crimping Jig <u>SAN 09-05-06</u> (4)		
3.0	LATHE CONV.	CONVENTIONAL LATHE
Comment: CONVENTIONAL LATHE Turn as per Dwg D3331 Identify as D3331-1 <u>mk 09/05/06</u> (4)		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>mk 09/05/06</u> (4)		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SA 09/05/06</u> (4)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 46746

Part Number: D3331041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 238032 3/16" Dowel Pin 1" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

3/16" Dowel Pin 1" long

Pick:

Qty	Part Number	Description	Batch
1	238-032	3/16"-1" long Dowel	M106162

pl 09.05.14

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- Deburr
- 2- Drill dowel hole as per Dwg D3331
- 3- Insert and Weld dowel as per Dwg D3331

Qty	Part Number	Description	Batch
A/R	N/A	Steel Rod	M9326

Batch M9326

pl 09.05.14

x4

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.05.14 (2)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 10:00AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:30AM

pl 09-05-27 (4)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

pl 09/05/27 (4)

11.0 GP78R Black Vinyl Grid



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Black Vinyl Grid

Pick:

Qty	Part Number	Description	Batch
1	GP-78R	Black Vinyl Grid	M11076

Batch M11076

pl 09.06.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 46746

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3158

Heat Shrink Tubing



Comment: Qty.: 0.4166 f(s)/Unit Total : 1.6664 f(s)

Heat Shrink

Pick:

Qty	Part Number	Description	Batch
5"	D3158	Heat Shrink	324615

Batch

324615

09-06-01

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg D3331

Identify as D3331-041

09-06-01

(X4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/01 (X4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl

09/06/02

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/02

Job Completion



MF

09-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	46746
Description: Handle		Part Number:	D3331-1
Inspection Dwg: D3331	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

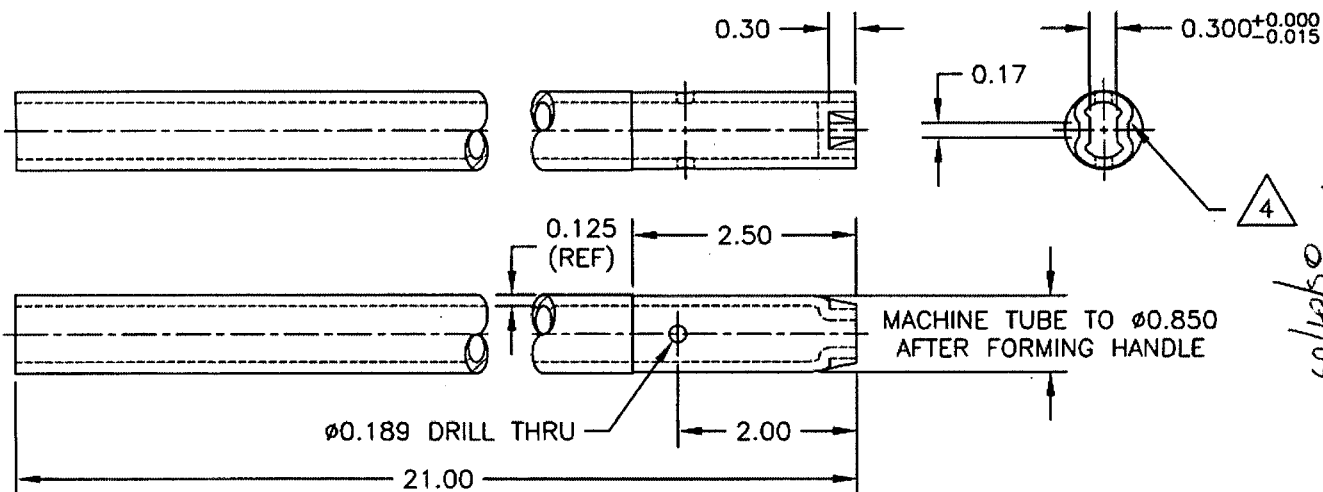
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.030	.290	✓			
0.17	+/-0.030	.160	✓			
0.300	+0.000/-0.015	.290	✓			
2.50	+/-0.030	2.500	✓			
Ø0.850	+0.000/-0.005	.849	✓			
0.125 wall	+/-0.010	.120	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	09/05/06	Date:	09/05/06	Date:	N/A

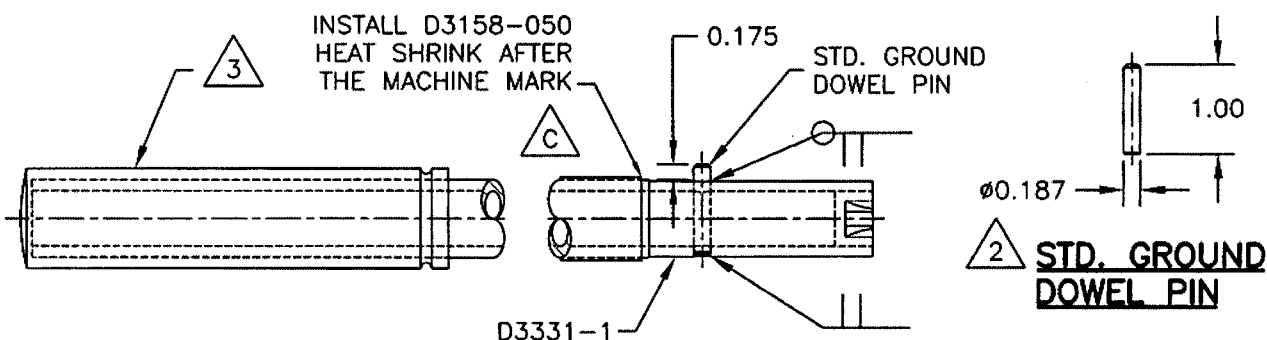
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D3331-041	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	<i>[Signature]</i>

DART

RELEASED
05/07/05



D3331-1 HANDLE



D3331-041 HANDLE ASS'Y

NOTES:

- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR0.875W.125)
- 2) STD. GROUND DOWEL PIN, $\frac{3}{16}$ " x 1.00" LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-032
- 3) STD. BLACK VINYL GRIP, $\frac{7}{8}$ " I.D. x 4 $\frac{3}{4}$ " LONG
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
- 4) FORM USING TOOLING DT8760
- 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11644

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
CHECKED	APPROVED	DRAWING NO. D3331	SHEET 1 OF 1
DATE		TITLE	SCALE
05.05.20		HANDLE WELDMENT	1:2
A	04.11.29	NEW ISSUE	
B	05.02.18	LENGTH 21.00 WAS 18.00	
C	05.05.20	ADD D3158-050	